

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011496**Date Inspected:** 18-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as 5CE+5BE hold back welds on bottom and side plate (cross beam side) "T" Stiffeners. The weld designations reviewed are as follows:

5BE

1. EP49-002-09, 010
2. DP630-001-15, 16
3. SP523-002-51, 52, 62, 63
4. SP563-002-37, 38, 47, 48
5. SP603-002-37, 38, 47, 48
6. BP165A-001-43, 44, 53, 54
7. BP157A-001-43, 44, 53, 54
8. BP111A-001-43, 44

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5CE

1. EP50-001-05, 06
2. DP631-001-15, 16
3. SP524-001-01, 02, 13, 14
4. SP564-001-01, 02, 11, 12
5. SP164-001-01, 02, 11, 12
6. SP166-001-01, 02, 11, 12
7. BP158A-001-01, 02, 11, 12
8. BP112A-001-01, 02

5CE

1. SP305-001-36, 37, 48, 49
2. SP332-001-31, 32, 41, 42
3. SP359-001-31, 32, 41, 42

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector observed a rejectable indication at the time of testing. QA Inspector observed one transverse indication, measuring approximately 6mm in length respectively. The QA Inspector generated a TL-6028 MT report on this date. Weld MT verified was identified as listed below:

5CE

1. BP112-001-001

This QA Inspector issued an incident report on the above noted MT rejection.

7AE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 002 located at CA033 cross beam side of segment. Welder is identified as Mr. Li Wenguo (220066). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc –U4b-FCM-1.

6AW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 006 located at OBW6F on counter weight side of segment. Welder is identified as Mr. Du Hengyou (037743). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-1 and WR #9844 repair procedure.

6CW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 010 located at OBW6F counter

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weight side of segment. Welder is identified as Mr. Li Bin (069896). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 009 located at OBW6F counter weight side of segment. Welder is identified as Mr. Cao Xinglong (069683). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 005 located at CA029-004 counter weight side of segment. Welder is identified as Mr. Yun Chuansheng (045221). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS345-SMAW-2G (2F)-FCM-Repair-1 and CWR #1058 repair procedure

Y Location of repairs areas by above noted welder (045221) is located at 1600mm.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
